



General Instructions

- Take lots of pictures as you take your carburetor apart. This will give you a reference of where things go.
- Using a cookie sheet with folded up sides will help keep parts from falling on the floor.
- We suggest not removing the throttle shaft, valves, or choke shaft unless they are corroded, or very dirty. These parts can be easily damaged and are difficult to re-assemble.
- Instruction sheets that come with our carburetor kits are somewhat generic. It may not match your parts exactly.
- Do NOT use WD-40 around your carburetor. It reacts with ethanol.
- Using Silicon Spray Lubricant on the gaskets will help with sticking in case you need to take the carburetor apart again.
- Be careful after taking the top of the carburetor off. Turning the carburetor upside down may cause parts to fall out and you won't know where they were.
- Screws and jets that are frozen can often be removed after heating outside the screw or jet.
- Stuck check balls can be removed by heating the outside of where the check ball resides and tapping the carburetor on the work bench.
- Do not discard any parts until complete done. You may have to refer for size, or matching.

Cleaning:

- Clean with carburetor dis-assembled.
- Soak all parts except rubber & electrical in Simple Green for 2 hours. Aluminum parts will get discolored if left longer.
- Wash parts with hot water if available to remove all chemicals.
- Blow out each passage way taking special notice of the smaller ones. Test each passage that air goes through the entire passage.
- Blow out the idle mixture hole.

- Check any hole above the idle mixture hole (inside the bore). This is the idle discharge and often becomes plugged.
- A tooth brush can facilitate cleaning parts.
- Soda blasting, then washing again will make the carburetor look good any will clean any minor deposits.
- Any corrosion, or deposits that are hard to remove may indicate the passages are also corroded and the carburetor should be replaced.
- If your engine has been sitting for 6 months or more, the gas has probably turned, and the gas tank will need to be cleaned as well as the fuel lines. Flushing new gas through the tank will not be enough.

Assembly:

- Do NOT apply any gasket sealant on any of the gaskets. Gas will break sealant part and the particles will clog the small passages.
- Test your float.
 - Brass floats should be immersed into hot water. As the air inside expands any leak will be noticeable with air bubbles.
 - Plastic, or Nitrophyl floats should be weighed. The weight is in grams. Check our technical pages for any weight specification that we may have.
- Most gaskets will fit as expected, but you may have to trim some, especially under the venturis.
- Your kit may include multiple gaskets in order to get better coverage out of the kit. Use the one that fits the best. Look for any opening the gasket may leave allowing air into the carburetor. Some holes may be casting holes that don't lead to anything and do not have to be covered.
- Mounting gaskets for multiple bore carburetors do not have to have matching holes. Example a four-barrel gasket can be open in the middle instead of 4 holes as long as the carburetor has some kind of passage between bores. The passage is between primary, or secondary, not both.
- When adjusting the float be careful not to put any pressure on the needle. The viton tip is easily damaged.
- Most idle mixture screws can be cleaned using a soft wire wheel. Inspect for any scoring, which would indicate over tightening. Screw with scoring should be replaced.

Accelerator Pumps:

- On leather cups run your finger around the inside of the cup to break any manufacturer sealant.
- Apply 2 drops of oil to cups (leather, or rubber) before inserting into carburetor. Do not soak the cup in oil. The swelling of the cup needs to happen inside the carburetor. Allow the 2 drops of oil and the gas to do its job naturally.
- Twist the pump as you are inserting to help keep the cup from curling or folding over.
- Test your accelerator pump circuit before putting the top of the carburetor back on. Our technical pages have instructions on how to do this for most carburetor types.
- Pump wells are usually slight tapered, and the pump will not seal until it gets towards the bottom.

INSTRUCTION SHEET

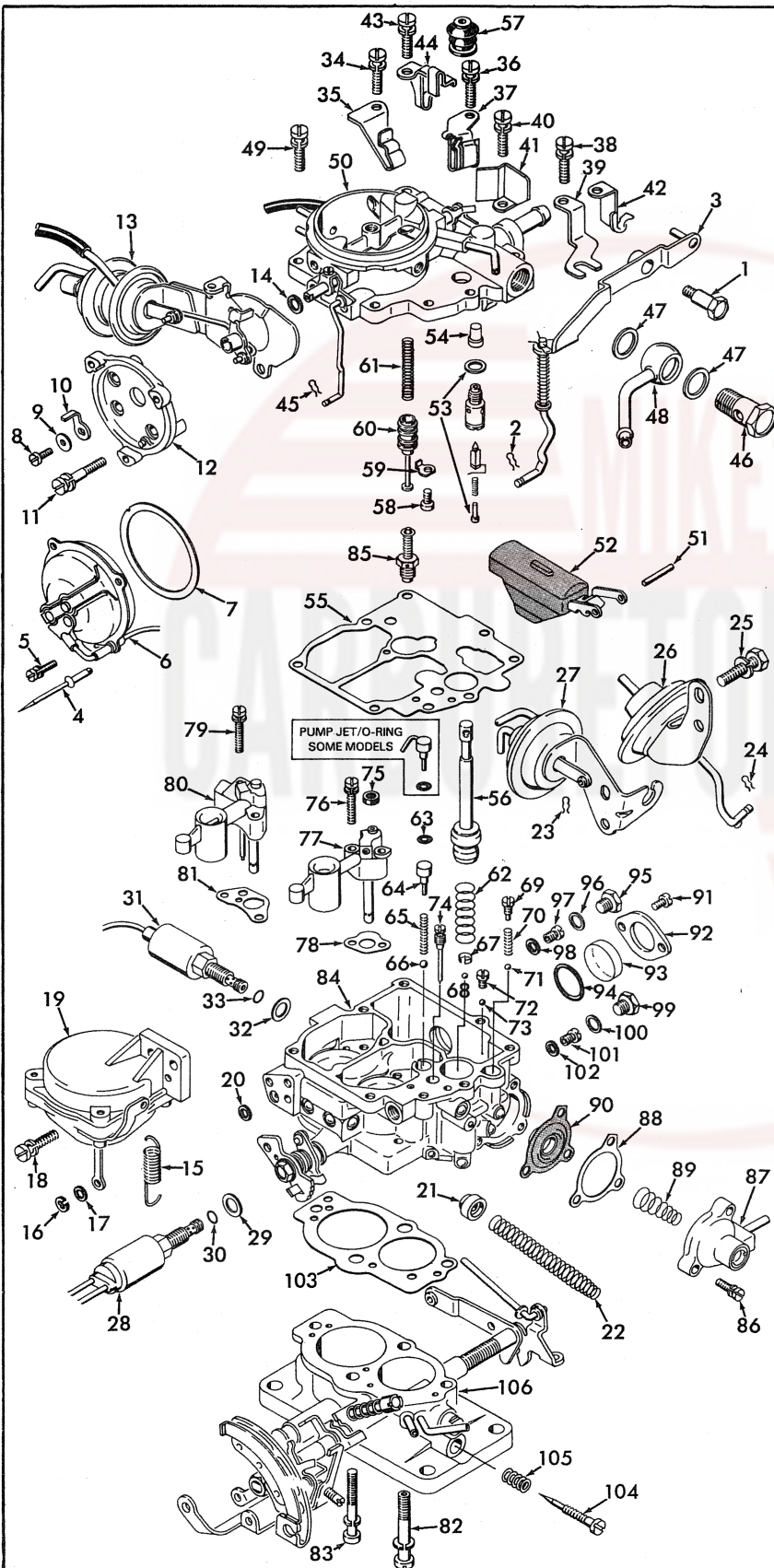
OFF VEHICLE CARBURETOR SERVICE

AISAN 2 BARREL

50-671-2

GENERAL EXPLODED VIEW

THE GENERAL DESIGN AND PARTS SHOWN WILL VARY TO
INDIVIDUAL UNITS COVERED ON THIS INSTRUCTION SHEET.



DISASSEMBLY

USE EXPLODED VIEW AS A GUIDE. THE NUMERICAL SEQUENCE MAY GENERALLY BE FOLLOWED TO DISASSEMBLE UNIT FAR ENOUGH TO PERMIT CLEANING AND INSPECTION. NOTE: TO REMOVE TAMPER RESISTANT RETAINER FROM CHOKE COVER, CAREFULLY DRILL RIVET HEADS OFF. REMOVE CHOKE COMPONENTS THEN KNOCK OUT REMAINDER OF RIVETS. DISASSEMBLY OF SECONDARY VACUUM UNIT (19) IS NOT NECESSARY UNLESS DIAPHRAGM IS BEING REPLACED. TO REMOVE IDLE MIXTURE NEEDLE PLUG, CENTER PUNCH CENTER OF PLUG, CAREFULLY DRILL A .255" HOLE IN PLUG. (NOTE THERE IS ONLY .040" CLEARANCE BETWEEN PLUG AND MIXTURE SCREW.) PRY REMAINDER OF PLUG FROM HOLE.

NOMENCLATURE

REF. NO.	REF. NO.
1. SCREW-PUMP LEVER	52. FLOAT ASSEMBLY
2. RETAINER-PUMP ROD	53. NEEDLE & SEAT ASSEMBLY
3. LEVER & CONNECTING ROD ASSY.-PUMP	54. SCREEN-FUEL FILTER
4. POP RIVET (4) SOME MODELS-RETAINER	55. GASKET-BOWL COVER
5. SCREW & LKWSHR. (3) SOME MODELS-RETAINER	56. PUMP PLUNGER ASSEMBLY
6. CHOKE COVER & RETAINER ASSY.	57. BOOT-PUMP
7. GASKET-CHOKE COVER	58. SCREW & LKWSHR.-PISTON RETAINER
8. SCREW-CHOKE SHAFT ARM	59. RETAINER-PISTON
9. WASHER-SCREW	60. PISTON-POWER VALVE
10. LEVER-CHOKE SHAFT	61. SPRING-POWER PISTON
11. SCREW & LKWSHR. (3)-CHOKE HOUSING	62. SPRING-PUMP RETURN
12. HOUSING-CHOKE	63. SEAL-PUMP WEIGHT
13. CHOKE PULL OFF & LINK ASSY.	64. WEIGHT-PUMP DISCHARGE SPRING
14. WASHER-LEVER SPACER	65. SPRING-PUMP DISC. BALL
15. SPRING-SEC. RETURN	66. BALL-PUMP DISC. CHECK (LARGE)
16. RETAINER-SEC. DIA. LINK	67. RETAINER-INTAKE CHECK BALL
17. WASHER-SEC. DIA. LINK	68. BALL-INTAKE CHECK (SMALL)
18. SCREW & LKWSHR. (2)-SEC. DIAPHRAGM	69. PLUG-AUX. PUMP CHECK BALL SPRING
19. SECONDARY DIAPHRAGM ASSY.	70. SPRING-AUX. CHECK BALL
20. GASKET-SEC. DIAPHRAGM ASSY.	71. BALL-AUX. PUMP DISC. CHECK
21. CUP RETAINER-SPRING	72. PLUG-AUX. PUMP CHECK BALL
22. SPRING-THROTTLE RETURN	73. BALL-AUX. PUMP INTAKE CHECK
23. RETAINER-AUX. PULL OFF LINK	74. JET-IDLE
24. RETAINER-T. P. LINK	75. SEAL-PRI. VENTURI
25. SCREW & LKWSHR. (2)-BRACKET	76. SCREW & LKWSHR. (2)-PRI. VENTURI
26. THROTTLE POSITIONER ASSY.	77. PRIMARY VENTURI ASSY.
27. AUX. PULL OFF ASSEMBLY	78. GASKET-PRI. VENTURI
28. SOLENOID ASSY.-PRI. IDLE CUT OFF	79. SCREW & LKWSHR. (2)-SEC. VENTURI
29. GASKET-SOLENOID	80. SECONDARY VENTURI ASSY.
30. O-RING-PRI. SOLENOID	81. GASKET-SEC. VENTURI
31. SOLENOID ASSY.-SEC. IDLE CUT OFF	82. SCREW & LKWSHR. (HOLLOW)-THROTTLE BODY
32. GASKET-SOLENOID	83. SCREW & LKWSHR. (3)-THROTTLE BODY
33. O-RING-SEC. SOLENOID	84. FLOAT BOWL ASSEMBLY
34. SCREW & LKWSHR.-BRACKET	85. POWER VALVE ASSEMBLY
35. BRACKET-WIRE LOOM	86. SCREW & LKWSHR. (3)-AUX. PUMP COVER
36. SCREW & LKWSHR.-BRACKET	87. COVER-AUX. PUMP DIAPHRAGM
37. BRACKET-WIRE LOOM	88. GASKET-AUX. PUMP COVER
38. SCREW & LKWSHR.-BRACKET	89. SPRING-AUX. PUMP DIAPHRAGM
39. BRACKET-FUEL PIPE	90. DIAPHRAGM-AUX. PUMP
40. SCREW & LKWSHR.-BRACKET & GAURD	91. SCREW (2)-RETAINER SIGHT GLASS
41. GAURD-CHOKE LINKAGE	92. RETAINER-SIGHT GLASS
42. BRACKET-WIRE LOOM	93. SIGHT GLASS
43. SCREW & LKWSHR.-BRACKET	94. O-RING-SIGHT GLASS SEAL
44. BRACKET-AUX. ROD GUIDE	95. PLUG-SEC. MAIN JET
45. RETAINER-FAST IDLE ROD (LOWER)	96. GASKET-PLUG
46. BOLT-FUEL INLET FITTING	97. JET-SEC. MAIN (CROME)
47. GASKET (2)-FUEL INLET FITTING	98. GASKET-SEC. MAIN JET
48. FITTING-FUEL INLET	99. PLUG-PRI. MAIN JET
49. SCREW & LKWSHR. (3)-BOWL COVER	100. GASKET-PLUG
50. BOWL COVER ASSEMBLY	101. JET-PRI. MAIN (BRASS)
51. PIN-FLOAT	102. GASKET-PRI. MAIN JET
	103. GASKET-THROTTLE BODY
	104. NEEDLE-IDLE ADJUSTING
	105. SPRING-IDLE ADJ. NEEDLE
	106. THROTTLE BODY ASSEMBLY

CLEANING

CLEANING MUST BE DONE WITH CARBURETOR DISASSEMBLED. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. (CAUTION: DO NOT PROLONG SOAKING OF PARTS CONTAINING PLASTIC MATERIALS THAT ARE NOT REMOVABLE.) MAKE CERTAIN THE THROTTLE BORES ARE FREE OF ALL CARBON DEPOSITS. WASH OFF IN SUITABLE SOLVENT. BLOW OUT ALL PASSAGES IN CASTINGS WITH COMPRESSED AIR AND CHECK CAREFULLY TO INSURE THOROUGH CLEANING OF OBSCURE AREAS. DO NOT SOAK DIAPHRAGM ASSEMBLIES, FLOAT, SOLENOIDS OR PARTS CONTAINING RUBBER MATERIAL.

REASSEMBLY

REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY. NOTE SPECIAL INSTRUCTIONS AND ADJUSTMENTS.

SPECIAL INSTRUCTIONS

IDLE ADJUSTING NEEDLE INSTALLATION. TURN NEEDLE IN UNTIL LIGHTLY SEATED, THEN BACK OUT 2 1/2-3 TURNS. FINAL ADJUSTMENT SEE CAR SERVICE MANUAL.

THROTTLE BODY SCREW & LOCKWASHER (HOLLOW) (82)-BE SURE TO INSTALL IN PROPER HOLE. (VACUUM PASSAGE FOR POWER VALVE PISTON.)

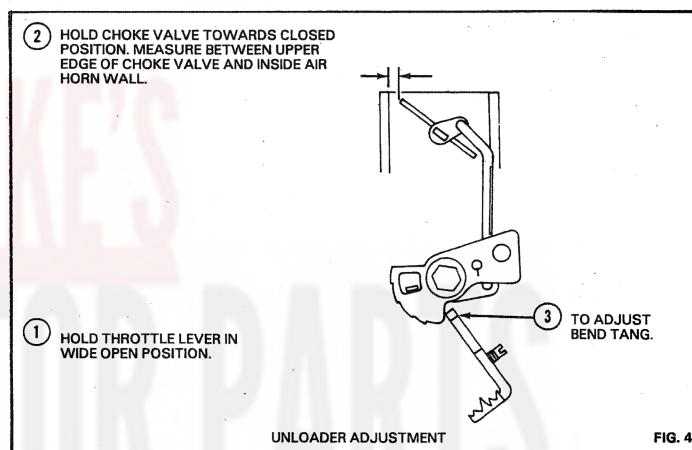
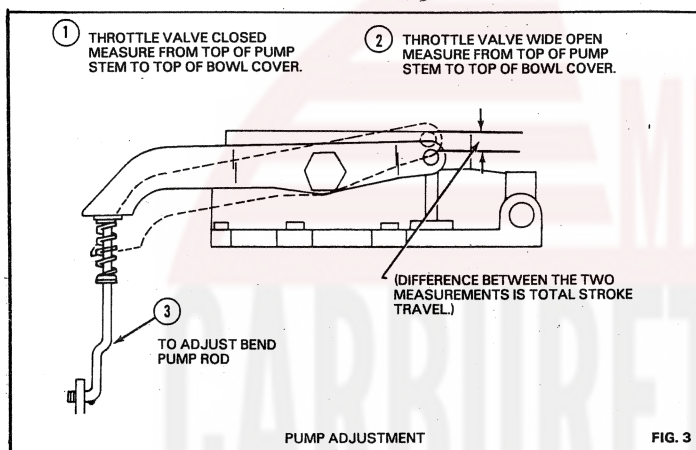
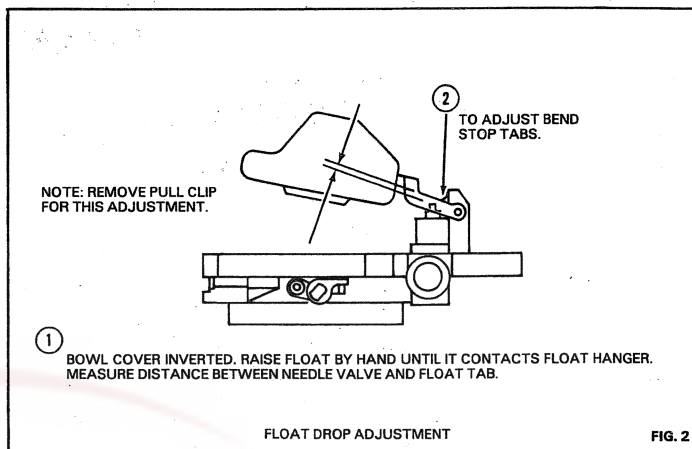
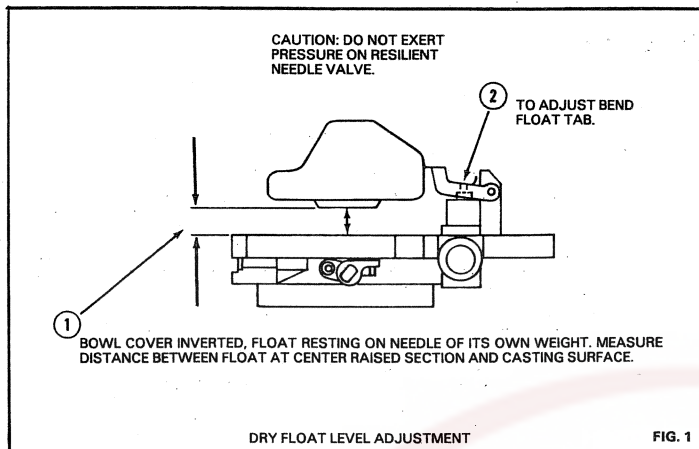
PUMP PLUNGER (56)-REMOVE PAPER SLEEVE FROM LEATHER CUP. FLEX LEATHER OUTWARD SLIGHTLY, SOAK CUP IN LIGHT OIL A FEW MINUTES PRIOR TO PLACING IN CARBURETOR.

BOWL COVER GASKET & FUEL INLET NEEDLE PULL CLIP. DO NOT INSTALL UNTIL FLOAT LEVEL & DROP HAVE BEEN SET.

WHEN INSTALLING CHOKE COVER BE SURE HOOK ON COIL SPRING IS AGAINST ARM OF CHOKE SHAFT. ALIGN NOTCH IN COVER WITH RAISED BOSS IN CASTING. (THIS TYPE OF CHOKE COVER IS NON ADJUSTABLE.) INSTALL NEW POP RIVETS.

CHOKE COVERS WITHOUT NOTCH, ALIGN MARK ON CHOKE COVER WITH INDEX MARK ON CHOKE HOUSING.

ADJUSTMENTS



ADJUSTMENT DATA TABLE

APPLICATION	DRY FLOAT LEVEL	FLOAT DROP	PUMP ADJ.	UNLOADER
1981-82 COROLLA 3T-C ENG.	9.2MM/3/8"	1.6MM/.063"	5.0MM/.197"	3.5MM/9/64"
1983-85 COROLLA 4A-C ENG. U.S.A.	7.2MM/9/32"	1.8MM/.070"	4.0MM/.157"	3.5MM/9/64"
1983-85 COROLLA 4A-C ENG. CAN.	7.2MM/9/32"	1.8MM/.070"	3.0MM/.118"	3.5MM/9/64"
1981 TERCEL 3A-C ENG.	4.0MM/5/32"	1.2MM/.047"	3.0MM/.118"	3.5MM/9/64"
1982 TERCEL 3A-C ENG.	7.2MM/9/32"	1.8MM/.070"	3.0MM/.118"	3.5MM/9/64"
1983-88 TERCEL 3A-C ENG. U.S.A.	7.2MM/9/32"	1.8MM/.070"	4.0MM/.157"	3.5MM/9/64"
1983-88 TERCEL 3A-C ENG. CAN.	7.2MM/9/32"	1.8MM/.070"	3.0MM/.118"	3.5MM/9/64"

REV. 10/85

INSTRUCTION SHEET

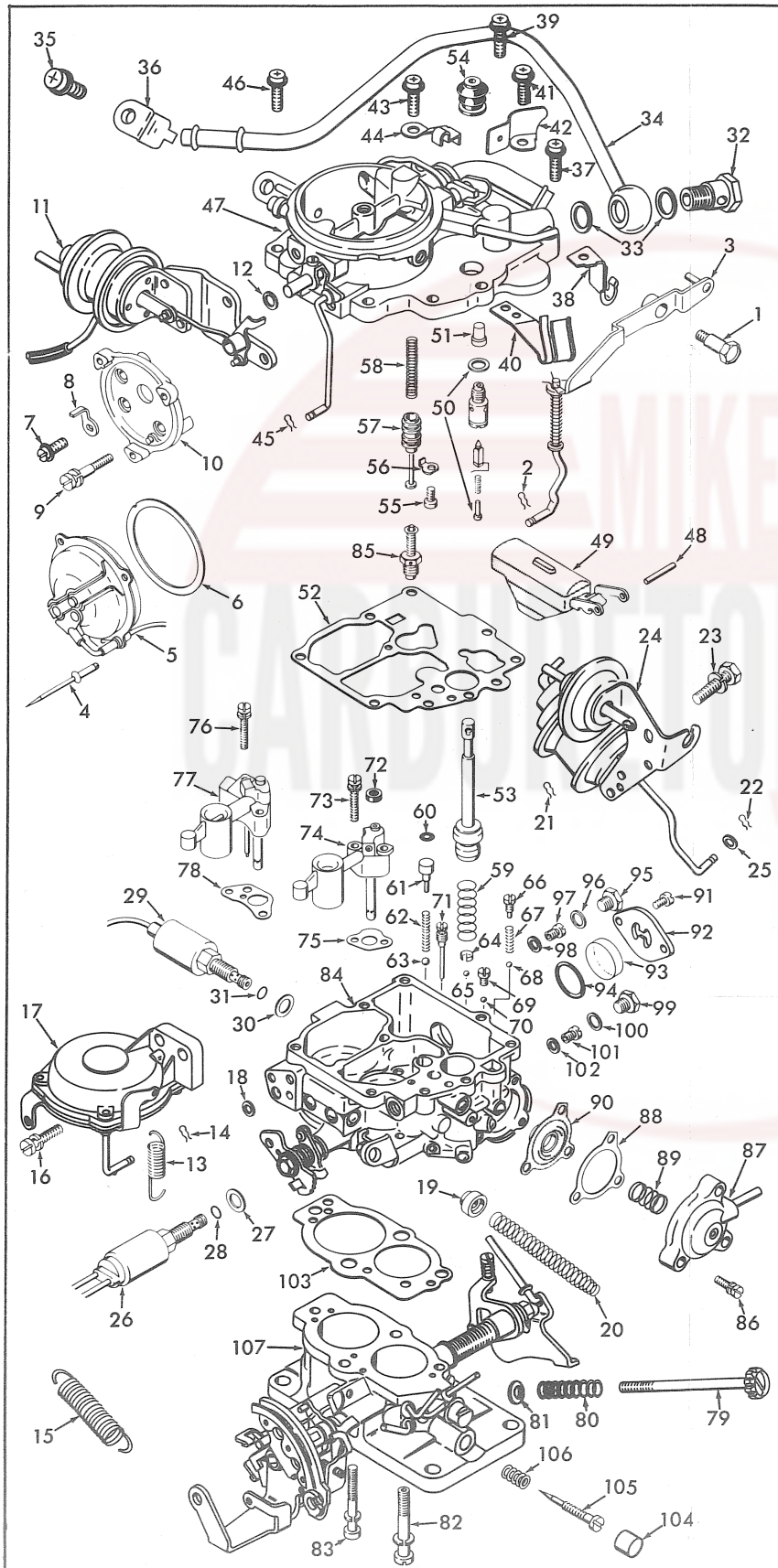
OFF VEHICLE CARBURETOR SERVICE

AISAN 2 BARREL

50-716-1

GENERAL EXPLODED VIEW

THE GENERAL DESIGN AND PARTS SHOWN WILL VARY TO INDIVIDUAL UNITS COVERED ON THIS INSTRUCTION SHEET.



DISASSEMBLY

USE EXPLODED VIEW AS A GUIDE. THE NUMERICAL SEQUENCE MAY GENERALLY BE FOLLOWED TO DISASSEMBLE UNIT FAR ENOUGH TO PERMIT CLEANING AND INSPECTION. NOTE: TO REMOVE TAMPER RESISTANT RETAINER FROM CHOKE COVER. CAREFULLY DRILL RIVET HEADS OFF. REMOVE CHOKE COMPONENTS THEN KNOCK OUT REMAINDER OF RIVETS. DISASSEMBLY OF SECONDARY VACUUM UNIT (19) IS NOT NECESSARY UNLESS DIAPHRAGM IS BEING REPLACED. TO REMOVE IDLE MIXTURE NEEDLE PLUG, CENTER PUNCH CENTER OF PLUG, CAREFULLY DRILL A .255" HOLE IN PLUG. (NOTE THERE IS ONLY .040" CLEARANCE BETWEEN PLUG AND MIXTURE SCREW.) PRY REMAINDER OF PLUG FROM HOLE.

NOMENCLATURE

REF. NO.	REF. NO.
1. SCREW - PUMP LEVER	55. SCREW & LOCKWASHER - PISTON RETAINER
2. RETAINER - PUMP ROD	56. RETAINER - PISTON
3. LEVER & CONNECTING ROD ASSY. - PUMP	57. PISTON - POWER VALVE
4. POP RIVET (3) - RETAINER	58. SPRING - POWER PISTON
5. CHOKE COVER & RETAINER ASSY.	59. SPRING - PUMP RETURN
6. GASKET - CHOKE COVER	60. SEAL - PUMP WEIGHT
7. SCREW - CHOKE SHAFT LEVER	61. WEIGHT - PUMP DISCHARGE SPRING
8. LEVER - CHOKE SHAFT	62. SPRING - PUMP DISC. BALL
9. SCREW & LOCKWASHER (3) - CHOKE HOUSING	63. BALL - PUMP DISC. CHECK (LARGE)
10. HOUSING - CHOKE	64. RETAINER - INTAKE CHECK BALL
11. CHOKE PULL OFF & LINK ASSY.	65. BALL - INTAKE CHECK (SMALL)
12. WASHER - LEVER SPACER	66. PLUG - AUX. PUMP CHECK BALL
13. SPRING - SEC. RETURN	67. SPRING - AUX. CHECK BALL
14. RETAINER - SEC. DIAPHRAGM LINK	68. BALL - AUX. PUMP DISC. CHECK
15. SPRING - THROTTLE RETURN	69. PLUG - AUX. PUMP CHECK BALL
16. SCREW & LOCKWASHER (2) - SEC. DIAPHRAGM ASSY.	70. BALL - AUX. PUMP INTAKE CHECK
17. SECONDARY DIAPHRAGM ASSY.	71. JET - IDLE (SLOW)
18. GASKET - SEC. DIAPHRAGM ASSY.	72. SEAL - PRI. VENTURI
19. RETAINER CUP - SPRING	73. SCREW & LOCKWASHER (2) - PRI. VENTURI
20. SPRING - THROTTLE RETURN	74. PRIMARY VENTURI ASSY.
21. RETAINER - AUX. PULL OFF LINK	75. GASKET - PRI. VENTURI
22. RETAINER - T.P. LINK	76. SCREW & LOCKWASHER (2) - SEC. VENTURI
23. SCREW & LOCKWASHER (2) - BRACKET	77. SECONDARY VENTURI ASSY.
24. THROTTLE POSITIONER ASSY. AND AUX. PULL OFF ASSY.	78. GASKET - SEC. VENTURI
25. WASHER - THROTTLE POSITIONER ROD	79. SCREW - IDLE ADJUSTING (RPM)
26. SOLENOID ASSY. PRI. IDLE CUT OFF	80. SPRING - IDLE SCREW
27. GASKET - SOLENOID	81. WASHER - IDLE SCREW SPRING
28. O-RING - PRI. SOLENOID	82. SCREW & LOCKWASHER - THROTTLE BODY (HOLLOW)
29. SOLENOID ASSY. - SEC. IDLE CUT OFF	83. SCREW & LOCKWASHER (3) - THROTTLE BODY
30. GASKET - SOLENOID	84. FLOAT BOWL ASSY.
31. O-RING - SEC. SOLENOID	85. POWER VALVE - ASSY.
32. BOLT - FUEL INLET FITTING	86. SCREW & LOCKWASHER (3) - AUX. PUMP COVER
33. GASKET (2) - FUEL INLET FITTING	87. COVER - AUX. PUMP DIAPHRAGM
34. FITTING - FUEL INLET	88. GASKET - AUX. PUMP COVER
35. SCREW & LOCKWASHER - BRACKET	89. SPRING - AUX. PUMP DIAPHRAGM
36. BRACKET - FUEL FITTING	90. DIAPHRAGM - AUX. PUMP
37. SCREW & LOCKWASHER - BRACKET	91. SCREW (2) - RETAINER SIGHT GLASS
38. BRACKET - WIRE LOOM	92. RETAINER - SIGHT GLASS
39. SCREW & LOCKWASHER - BRACKET	93. SIGHT GLASS
40. BRACKET - WIRE LOOM	94. O-RING - SIGHT GLASS SEAL
41. SCREW & LOCKWASHER - GAURD	95. PLUG - SEC. MAIN JET
42. GAURD - CHOKE LINKAGE	96. GASKET - PLUG
43. SCREW & LOCKWASHER - BRACKET	97. JET - SEC. MAIN (CROME)
44. BRACKET - AUX. ROD GUIDE	98. GASKET - SEC. MAIN JET
45. RETAINER - FAST IDLE ROD (LOWER)	99. PLUG - PRI. MAIN JET
46. SCREW & LOCKWASHER (4) - BOWL COVER	100. GASKET - PLUG
47. BOWL COVER ASSEMBLY	101. JET - PRI. MAIN (BRASS)
48. PIN - FLOAT	102. GASKET - PRI. MAIN JET
49. FLOAT ASSEMBLY	103. GASKET - THROTTLE BODY
50. NEEDLE & SEAT ASSY.	104. PLUG - IDLE NEEDLE
51. SCREEN - FUEL FILTER	105. NEEDLE - IDLE MIXTURE
52. GASKET - BOWL COVER	106. SPRING - IDLE NEEDLE
53. PUMP PLUNGER ASSY.	107. THROTTLE BODY ASSY.
54. BOOT - PUMP	

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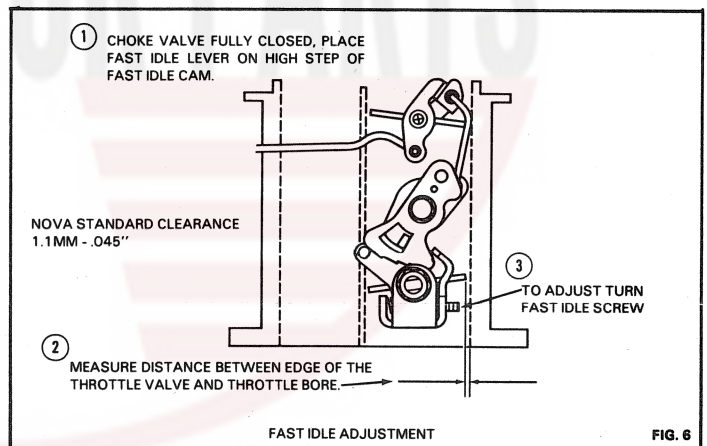
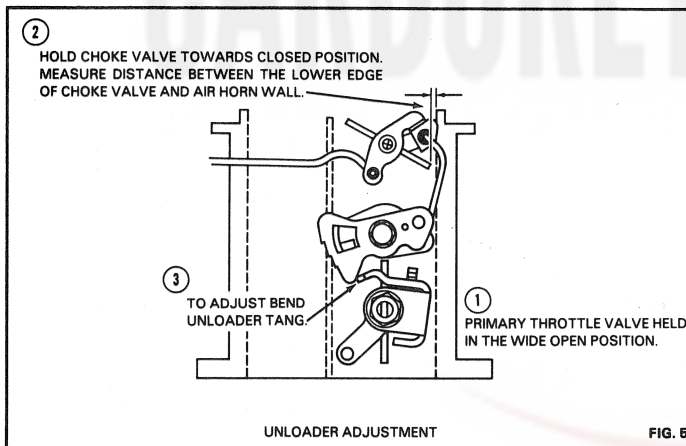
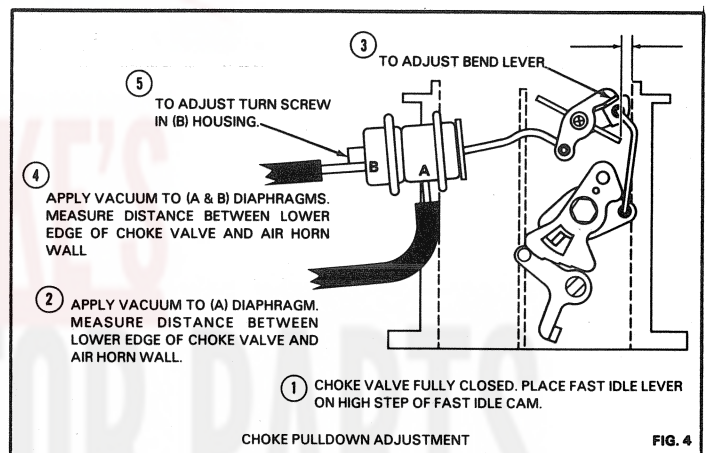
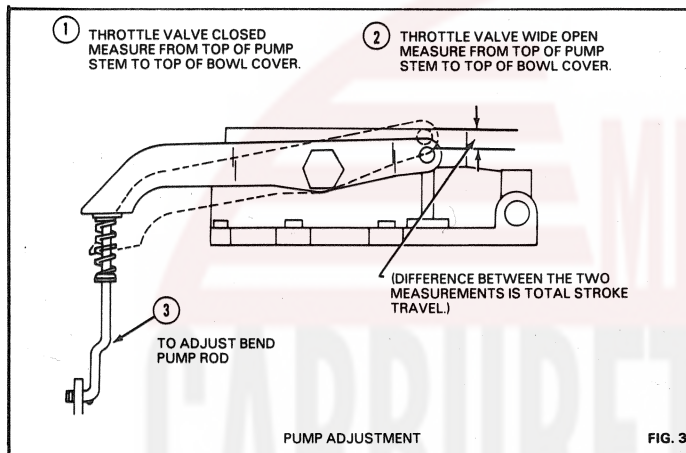
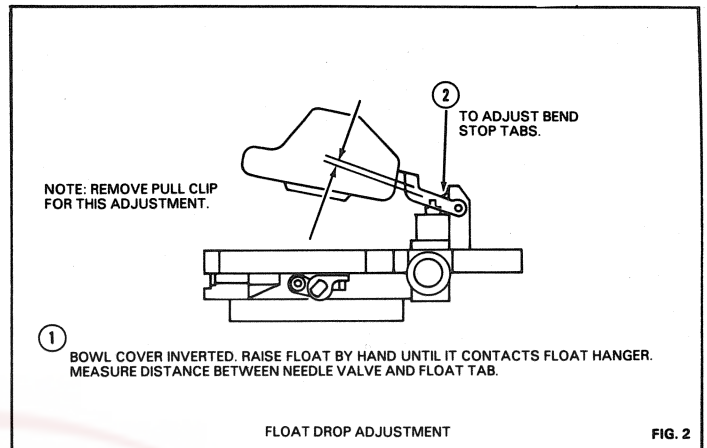
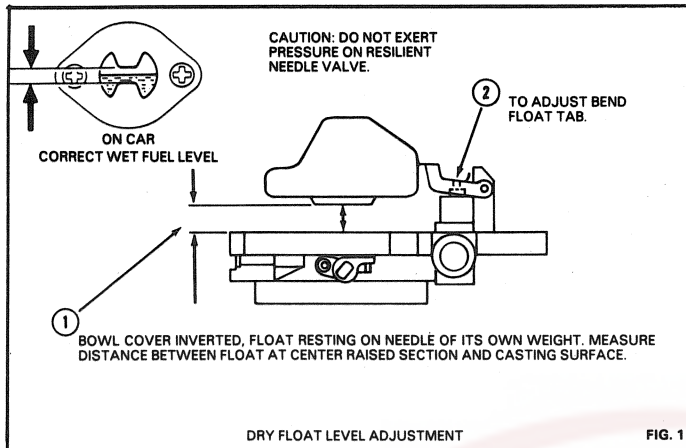
THROTTLE BODY SCREW & LOCKWASHER (HOLLOW) (82) - BE SURE TO INSTALL IN PROPER HOLE (VACUUM PASSAGE FOR POWER VALVE PISTON).

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BOWL COVER GASKET & FUEL INLET NEEDLE PULL CLIP. DO NOT INSTALL UNTIL FLOAT LEVEL & DROP HAVE BEEN SET.

WHEN INSTALLING CHOKE COVER BE SURE HOOK ON COIL SPRING IS AGAINST ARM OF CHOKE SHAFT. ALIGN NOTCH IN COVER WITH RAISED BOSS IN CASTING. (THIS TYPE OF CHOKE COVER IS NON ADJUSTABLE.) INSTALL NEW POP RIVETS.

ADJUSTMENTS



ADJUSTMENT DATA TABLE

APPLICATION	FLOAT LEVEL	FLOAT DROP	PUMP STROKE	CHOKE PULLDOWN	UNLOADER
1984-85 COROLLA 4A-C ENG. U.S.A.	7.2MM-9/32"	1.8MM-.070"	4.0MM-.157"	A-38° B-55°	41°
1984-85 COROLLA 4A-C ENG. CAN.	7.2MM-9/32"	1.8MM-.070"	3.0MM-.118"	A-39° B-50°	47°
1986 COROLLA 4A-C ENG. U.S.A.	7.2MM-9/32"	1.8MM-.070"	2.0MM-.079"	A-38° B-50°	41°
1986 COROLLA 4A-C ENG. CAN.	7.2MM-9/32"	1.8MM-.070"	3.0MM-.118"	A-39° B-50°	47°
1985 NOVA 1.6L ENG.	7.2MM-9/32"	1.8MM-.070"	4.0MM-.157"	A-.095"-2.4MM B-.254"-6.2MM	.120"-3MM
1986 NOVA 1.6L ENG.	7.2MM-9/32"	1.8MM-.070"	2.0MM-.079"	A-.095"-2.4MM B-.254"-6.2MM	.120"-3MM
1987 NOVA 1.6L ENG.	7.0MM-9/32"	1.8MM-.070"	2.0MM-.079"	A-.095"-2.4MM B-.254"-6.2MM	.120"-3MM

WHEN DEGREE SETTINGS OR GIVEN, A SPECIAL PROTRACTOR GAUGE IS NEEDED TO MEASURE ANGLE OF CHOKE VALVE.